

**ABSTRACT**

An apparatus for cutting sheet metal pieces from a sheet metal coil comprises a coil support adapted to support the 5 sheet metal coil such that same may rotate about the coil axis to unroll an end portion of the sheet metal coil and a sheet support adapted to support the end portion for cutting. A cutting head is mounted above the end portion and is operative to cut through the end portion. A cutting 10 head drive is operative to move the cutting head back and forth along a first path parallel to the coil axis and a sheet metal drive is operative to move the end portion forward and rearward along a second path perpendicular to the coil axis. A computer is operative to control and 15 coordinate the sheet metal drive and the cutting head drive such that the pieces are cut from the end portion.

1002523-4-D-0301